

Work Order ID 59885

Tuesday, June 15, 2010 2:16:17 PM



Page 1

Item ID: D3584-1

Accept



Setup Start



Revision ID:

Item Name: Web

Stop



Start Date: 6/15/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan: HDate: 10/6/17 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3584

Rev A

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut to Length as per Dwg D3584
2-Drill Pilot Holes using DT8960 Drill Jig
3-Open pilots to 1.000" as per Dwg D3584
4-Deburr

2xMB 10-06-17

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

2xBE 10/06/17

120

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

2xMB 10-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59885

Tuesday, June 15, 2010 2:16:17 PM



Page 2

Item ID: D3584-1

Accept



Setup Start



Revision ID:

Item Name: Web

Stop



Start Date: 6/15/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC3- Inspect Part Finish

0.00

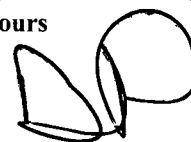


QC

Memo

0.00

Quality Control



10-6-17



140

Identify as per dwg & Stock Location *speller* 0.00



Packaging

Memo

0.00

Packaging



&

MB 10-06-17

150

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

10/06/17 *MF*

MF 10-6-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 15, 2010 2:16:21 PM

Page 1

Work Order ID: 59885

Parent Item: D3584-1

Parent Item Name: Web



Start Date: 6/15/2010

Required Date: 6/18/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07.06.12 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2963-125 105 I Beam Extrusion		Manufactured	No			110	Each	126.0000	1	2			

2x MS 20-06-17

Location	Loc Qty	Loc Code
HALL	126	
27775	8	
28673	118	

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

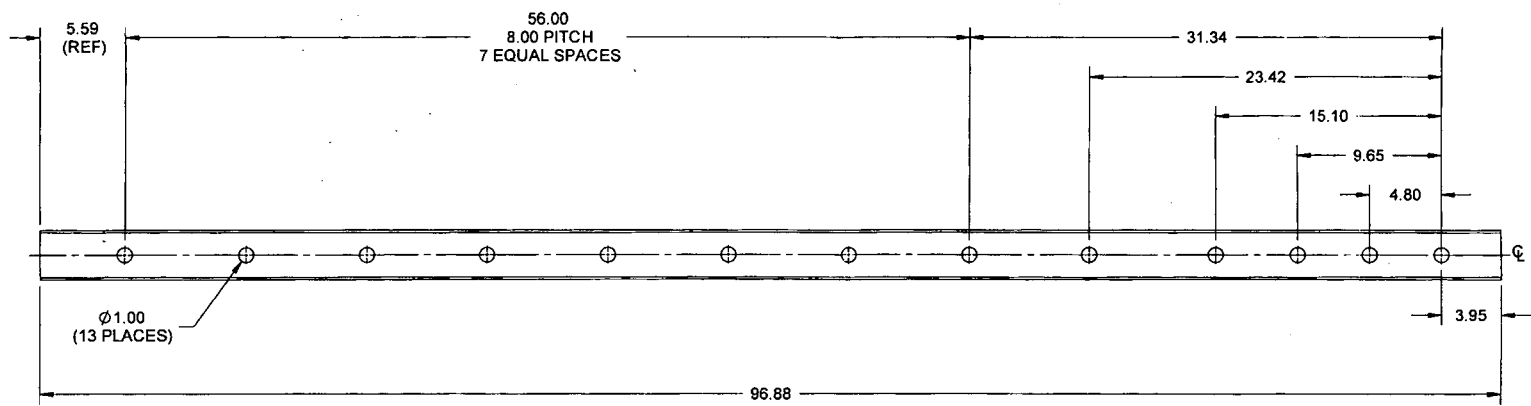
C

B

B

A

A



D3584-1 WEB

RECEIVED
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
BY THE NOTICE
1. REV. 1
NO. 39885
PH 10-6-15

RELEASED
07.11.22

- NOTES:
- 1) MATERIAL: MAKE FROM D2963-125 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010 TO 0.020
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 5.08 lbs

A		NEW ISSUE		PH	07.06.08
REV.		DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWN	PH				
CHECKED	PH	DRAWING NO.	D3584	REV. A	
MFG. APPR.	PH	SHEET 1 OF 1			
APPROVED	PH	TITLE	WEB	SCALE	1:8
DE APPR.	PH				
DATE	07.06.08				

COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

8 7 6 5 4 3 2 1